

*Split**v6*

Date: Thursday, 31/07/2008 12:18:52 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: HELI-ACCESS STEP LH (FOLDING)		
Job Number	: 40857 <i>2</i>			Part Number	: D412630033		
Estimate Number	: 12567			Drawing Number	: IIN D412-630		
P.O. Number	:			Project Number	: N/A		
This Issue	: 31/07/2008 S.O. No. :			Drawing Revision	: L		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 25/08/2008 Qty: <i>2</i>		
Previous Run	: 40268			Um:	Each		
Written By	:						
Checked & Approved By	: <i>DU 08.8.01</i>						
Comment	: Est. Rev:A New Issue 06-11-08 JLM est rev B ecn 1019, added d2807-041 EC verified by:DD						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-033 CHG003	<i>S 08/07/02</i>
2.0	D2012107	Clevis	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Clevis Pick: Qty Part Number Description Batch	<i>A8 08/08/06 (X5)</i> <i>B33585 x4 40274 x1</i>
3.0	D2803041	Bracket Assembly	 <i>35826 x4 A8/08/07</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch	
4.0	D2804041	Bracket Assembly	 <i>40278 A8/08/07</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch	

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Seq. #:	Machine Or Operation:	Description :
5.0	D2807041	Gas Spring Assembly 
6.0	D2813	Washer 
7.0	D3562041	Step Assembly, LH 
8.0	D33951	Bushing 
9.0	AN3C21A	BOLT 

Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) *AS 08/08/07 (X5)*

Support Prop  
Batch: *35751*

Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) *AS 08/08/07 (X5)*

Washer  
Pick:  
Qty Part Number Description Batch  
2 D2813 Washer *34020*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) *AS 08/08/07 (X5)*

Step Weldment LH  
Pick:  
Qty Part Number Description Batch  
1 D3562-041 Step Weldment LH *B41245*

Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) *AS 08/08/07 (X5)*

Bushing  
Pick:  
Qty Part Number Description Batch  
4 D3395-1 Bushing *33578*

Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) *AS 08/08/07 (X5)*

BOLT  
Pick:  
Qty Part Number Description Batch  
2 AN3C21A Bolt *101189*

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Job Number:



Seq. #: Machine Or Operation:

15.0 NAS1515H8 Washer

Description :



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)  
Washer



Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

106540 x 11 M106575 x 9



16.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)  
Nut



Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M108618 x 4 M108672 x 16



17.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Screw

Batch

M101390



18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor  
A/R LPS3 batch: U109929

COAT exposed HARDWARE WITH LPS PROCYON .

A/R LPS PROCYON BATCH: M104251

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/08 (2) +2 LHD

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Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-1	Bushing	35430

22.0 D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	334019

23.0 D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	4629

24.0 D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	34025

25.0 AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C6A	Bolt	MV7242

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Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
1	AN4C6A	Bolt
26.0	AN4C10A	Bolt
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
	Bolt	
	Pick: Packing Kit	
	Qty Part Number	Description
1	AN4C10A	Bolt
27.0	AN4C15A	Bolt
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)		
	Bolt	
	Pick: Packing Kit	
	Qty Part Number	Description
2	AN4C15A	Bolt
28.0	AN44C7A	Eyebolt
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
	Eyebolt	
	Pick: Packing Kit	
	Qty Part Number	Description
1	AN44-C7A	Eyebolt
29.0	AN5C15A	Bolt
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)		
	Bolt	
	Pick: Packing Kit	
	Qty Part Number	Description
2	AN5C15A	Bolt
30.0	NAS1515H4	Washer
<b>Comment:</b> Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)		
	Washer	
	Pick: Packing Kit	
	Qty Part Number	Description
7	NAS1515H4	Washer

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Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	NAS1515H5	Washer
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H5	Washer	M108334



AS 08/09/02 (X)

32.0	MS210434	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	MS21043-4	Nut	M108472



AS 08/09/02 (X)

33.0	MS210435	Nut
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
3	MS21043-5	Nut	M108583



AS 08/09/02 (X)

34.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location: \_\_\_\_\_

PPP Rev: A

8/9/02

(X)

SO

36.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE



08/09/02 (X)

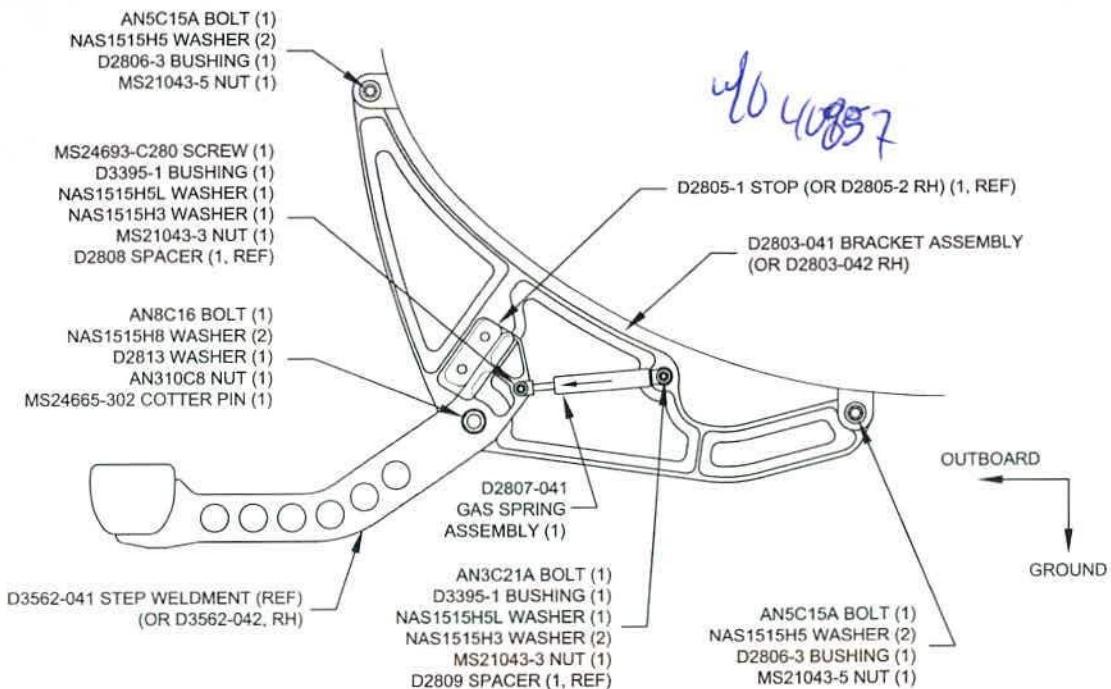
Job Completion



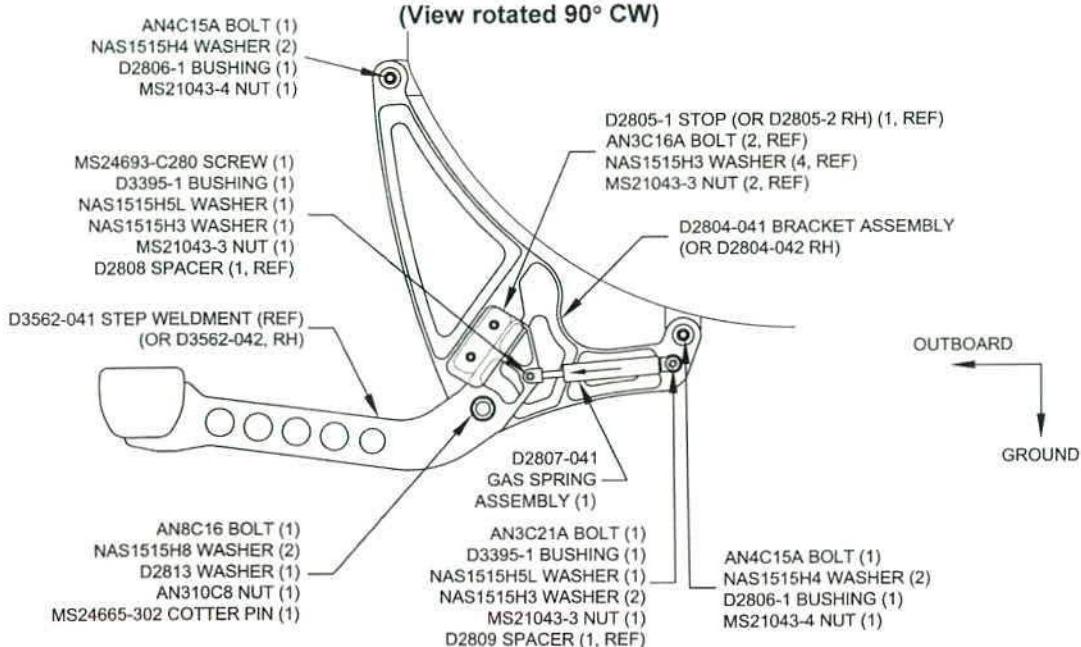
u 08/09/02

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
			1	D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
			1	D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
			1	D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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NO. LL685!

D412-630-033/-034 Heli-Access-Step™ Installation

**FIGURE 25-13: STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)



**FIGURE 25-14: STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)

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